

**Work Order ID 61864**

September 8, 2010 11:52:30 AM



Page 1

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/27/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/9/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2273

D

D350-604-041

A

DSI9470

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

8/10/12/26

H for 10-9-28

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 12533

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 115502 CZ 10/9/19

CZ 10/9/18 D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61864**

September 8, 2010 11:52:30 AM

Page 2

Item ID: D350-604-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rear Locker Extender

Start Date: 9/08/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/27/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive & Insp for Damage & Mat'l Certs  
Packaging

0.00

Packaging

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

140

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61864**

September 8, 2010 11:52:30 AM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rear Locker Extender

Start Date: 9/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/27/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC4- 100% Inspect kits for completeness

0.00

8/10/08/25

20



QC

Memo

0.00

Quality Control

160

Packaging

0.00



Packaging

Memo

0.00

10/10/08/25

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: 58

PPP Rev: 4

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29  
MF  
10-9-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

September 8, 2010 11:52:30 AM

Page 1

Work Order ID: 61864

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender



Start Date: 9/08/10

Required Date: 9/27/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01 Reformat KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 		Purchased	No			110	Each	109.0000	4	4			
Camlock Stud													

Location	Loc Qty	Loc Code
ST381	109	
114238	4	
114355	4	
115178	20	
115502	51	
115581	30	

D350-604-041P 	Purchased	No				120	Each	3.0000	1	1			
Rear Locker Extender													

Location	Loc Qty	Loc Code
ST	3	
61290	1	
61291	1	
61292	1	

D2268 	Manufactured	No				140	Each	13.0000	1	1			
Decal													

Location	Loc Qty	Loc Code
ST010	13	
57535	3	
60213	10	

4 C212/919

61864

14/9/28

6213

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

September 8, 2010 11:52:30 AM

Work Order ID: 61864



Parent Item: D350-604-041



Parent Item Name: Rear Locker Extender

Start Date: 9/08/10

Required Date: 9/27/10

Start Qty: 1.00

Required Qty: 1.00

D2269

Manufactured No

140

Each

9.0000

1

1



Decal

*Le 14/9/28*

Location

Loc Qty

Loc Code

ST010

9

57536

3

60214

6

*60214*

September 8, 2010 11:52:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

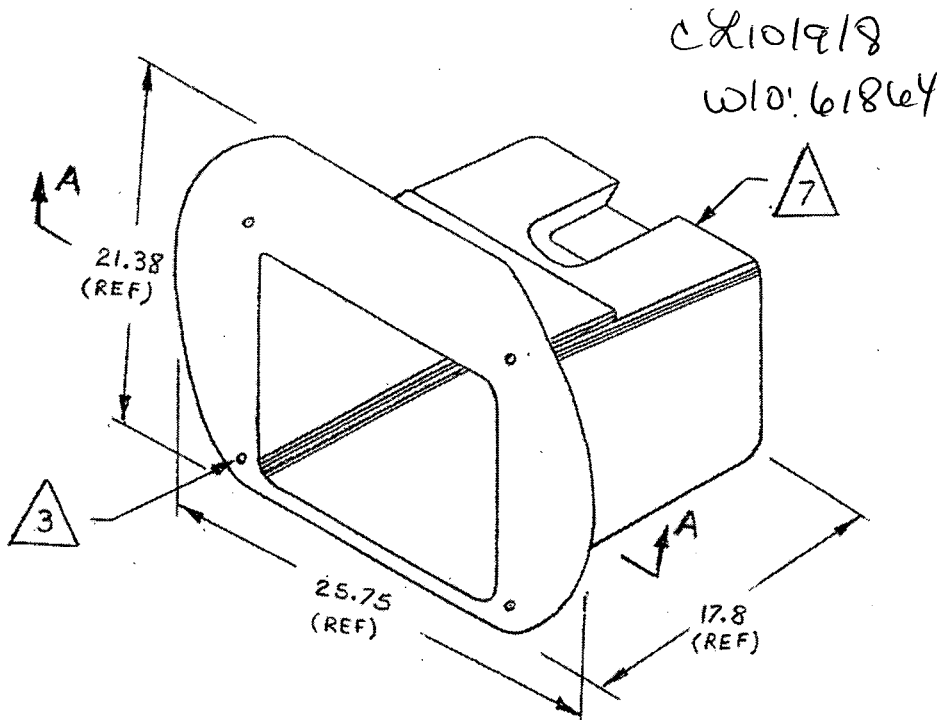
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

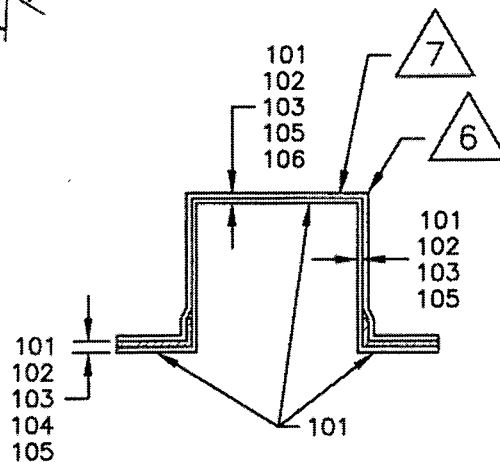
NOTE: Date & initial all entries

**DART**

DESIGN	JB	DRAWN BY	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER	SCALE	NTS
B	96.05.27	RE-DRAWN			
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING			
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH			

**RELEASED**  
02.04.03**NOTES:**

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\phi 0.257$  (4 PLACES).
- 4) MATERIALS:  
RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS  
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:  
101-WHITE GLOSS GELCOAT # GEL 944W005.  
102-9oz ALL OVER.  
103-18oz ALL OVER.  
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.  
105-9oz ALL OVER.  
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD\*GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.

**SECTION A-A**

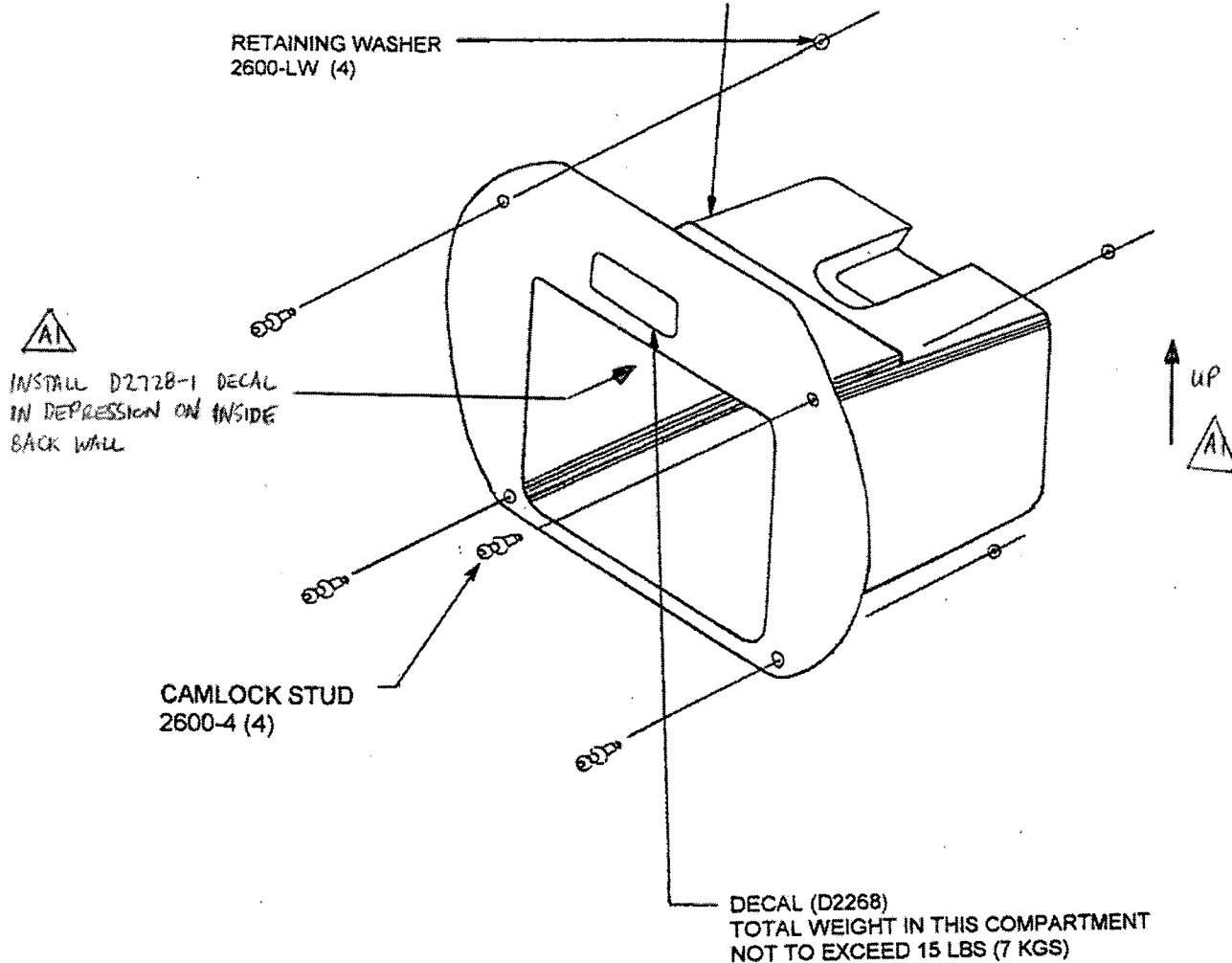
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DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
AI	02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE REAR LOCKER EXTENDER (D2273)	

RELEASED  
02.04.03



### D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4  
REF FAA STC: SR00463NY

## PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

## CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y

## IS:

4	2600-6	CAMLOC STUD
---	--------	-------------

## WAS:






4	2600-4	CAMLOC STUD
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CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.07.01  
CERT. NO.: SH90-4  
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	VIA	DSI 9470	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	34967
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

**Bill to:**  
DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**  
DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
24/09/2010	10/09/2010	15288	Chantal Lavoie		PO12533		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line 1 Rear Locker Extender D350-604-041P B61861 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> <u>No. lot</u> B6186127875			
1	0	1	DKC134-0003	Line 2 Rear Locker Extender D350-604-041P B61863 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> <u>No. lot</u> B61863.27876			
1	0	1	DKC134-0003	Line 3 Rear Locker Extender D350-604-041P B61864 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> <u>No. lot</u> B6186428713			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

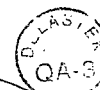
Continued on next page

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:

Quality department

AQ-357



10/09/22



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	34967
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

**Bill to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200  
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
24/09/2010	10/09/2010	15288	Chantal Lavoie		PO12533		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line 4 Rear Locker Extender D350-604-041P B61865 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D  <u>No. série</u> B61865  <u>No. lot</u> 28714			

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by

Quality department AQ-357

Mercredi, 2010-09-08 11:23:35

sateur: Pascal Carignan

Feuille de Procédé

<b>Client</b> :	DART US DART AEROSPACE LTD	<b>Nom Dessin</b> :	REAR LOCKER EXTENDER
<b>Numéro Job</b> :	28713	<b>Numéro Article</b> :	DKC134-0003
<b>Numéro Soumission</b> :	3482	<b>Numéro Dessin</b> :	D350-604-041 & D2273
<b>Numéro B.A.</b> :		<b>Projet Numéro</b> :	DK-362
<b>Cette fois</b> :	2010-09-08	<b>Révision dessin</b> :	A & D
<b>Prsht Rev.</b> :	NC	<b>Matériel</b> :	Derakane 470-36/411/510
<b>Prem. fois</b> :	- -	<b>Date Dûe</b> :	2010-09-15
<b>Job précédente</b> :	27876	<b>Qté:</b>	1 UdM: UNITE
<b>Écrit par</b> :			
<b>Vérifié &amp; Approuvé par</b> :			
<b>Commentaires</b> :	N° de pièce Laminée Dart Aerospace: D2273 N° de pièce Assemblage Dart Aerospace: D350-604-041		

Process Sheet Rév.: 00 Création du premier à partir de la révision  
12 du planning De Delastek Composites

**B 61864****Produit additionnel**

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.02 UNITE(s)/Unit Total : 0.02 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant efficace. Il est permis d'utiliser un abrasif (Doux) afin d'enlever toute accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-28089-1

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1



Date: Mercredi, 2010-09-08 11:23:35  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28713

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

5.0	AC0747	Acetone
-----	--------	---------

Commentaire Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon I.F. # DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 15-9-10 Sceau:



7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Selon I.F. 134-0003

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. ( Visuel du Gel Coat )

Date: 15-9-10 Sceau:



8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
-----	---------	---

Commentaire Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-28/77-1

9.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22/76-1

10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentaire Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-27985-1

Date: Mercredi, 2010-09-08 11:23:35

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28713

Numéro Article: DKC134-0003

Numéro Job:



# Séq.: Machine ou Opération: Description :

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentaire Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)  
WR1850 Roving 18oz. x 50" N° de Lot: 1-22302-1

12.0 PREP-GENERAL Préparation du matériel



Commentaire Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. ( Selon gabarits )

Date: 15/09/10 Sceau:



13.0 LAMINAGE Faire le laminage



Commentaire Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon I.F. 134-0003

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 31% Température: 74°F Heure: —

Date:



Sceau: 16/09/10

14.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: —

15.0 AMB0286 Catalyst N° DDM-9

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: —

16.0 FINITION Finition Générale



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon I.F.# DKC134-0003-5.

Date: —

Sceau: —

Date: Mercredi, 2010-09-08 11:23:35  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD  
Numéro Job: 28713

Nom Dessin: REAR LOCKER EXTENDER  
Numéro Article: DKC134-0003

Numéro Job:



# Séq.: Machine ou Opération: Description :

17.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Autocontrôle de fabrication.( Visuel )

Date: 17-9-10 Sceau:



18.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon I.F.134-0002

Autocontrôle de fabrication.( Visuel et dimensionel selon le dessin )

Date: 20-9-10 Sceau:



19.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-26804-3

20.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 2-27790-3

21.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon I.G. 0008

Date: 21/09/10 Sceau:



22.0 AAC1607 Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)  
Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot: 1-28208-1

Date: Mercredi, 2010-09-08 11:23:35

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 28713

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

23.0

AAC0682

Washer 2600-LW (1127700)

Commentaire Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot:

1-6687-1

24.0

ASSEMBLAGE

Assemblage mécanique



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage ( Visuel )

Date:

22/09/10

Sceau:



25.0

IDENTIFICATION

Identification à encre indélébile



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041

N° de Work Order: \_\_\_\_\_

L'identification doit être vers l'extérieur.

Date:

22/09/10

Sceau:



26.0

INSPEC FINAL

Inspection finale



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date:

22-9-10

Sceau:



27.0

EMBALLAGE

Emballage & Entreposage



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

1 23 sept 10 SD

**Date:** Mercredi, 2010-09-08 11:23:35  
**Utilisateur:** Pascal Carignan

## Feuille de Procédé

**Client:** DART US DART AEROSPACE LTD

**Nom Dessin:** REAR LOCKER EXTENDER

**Numéro Job:** 28713

**Numéro Article:** DKC134-0003

**Numéro Job:**



**# Séq.:**

**Machine ou Opération:**

**Description :**

**Date:** \_\_\_\_\_ **Sceau:** \_\_\_\_\_